

**ABSTRACT OF THE DISCLOSURE**

A method of determining eccentricity of a hollow billet in the course of rolling in seamless tubing or seamless pipe manufacture whereby at the outlet side of an inclined roll mill at least one measurement head is provided for ultrasonic wall thickness measurement and the results of a number of measurements are processed by Fast Fourier Transform analysis series elements which approximate the eccentricity as a result of the helical or spiral superimposition of an eccentricity amplitude on the mean eccentricity in terms of the wall thickness of the hollow billet.

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